Date: User:

Thursday, 13/11/2008 8:08:28 AM

Linda Lacelle



## **Process Sheet**

Customer

: CU-DAR001 Dart Helicopters Services

Job Number **Estimate Number** 

: 43404 : 11063

P.O. Number

This Issue

: 13/11/2008

: NC

Prsht Rev. First Issue

: //

Type

: SMALL /MED FAB

S.O. No. :

: 42262 **Previous Run** 

Written By

Comment

Checked & Approved By

New Issue EC : Est A 00.06.06

Est Rev:B Now 6061-T6 06-06-23 JLM

**Drawing Name** 

: SADDLE SPACER

Part Number

: D2935 : D2935 REV B

**Drawing Number** Project Number

: N/A

**Drawing Revision** 

Material

: 20/11/2008 **Due Date** 

Qty:

20 Um:

Each

**Additional Product** 

Job Number:



Seq. #:

Machine Or Operation:

Description: 6061-T6 .080 Sheet

1.0

M6061T6S080

0.0532 sf(s)/Unit Total:

1.0647 sf(s)

Material: M6061-T6 0.080" Thick

Batch <u>109784</u>

8-11-13

2.0

WATER JET

Comment: Qty.:



B

FLÓW WATER JET

**Comment: FLOW WATER JET** 

1-Cut as per Dwg D2935

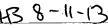
Dwg Rev:\_ Prog Rev:\_

2-Deburr if necessary

3.0

QC2





Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK.

HAND FINISHING1

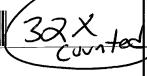


HAND FINISHING RESOURCE #1



· Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1



## **Dart Aerospace Ltd**

W/O:			WO	RK ORDER CHAN	GES					
DATE	STEP	PR	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
•										
								-		
1										
Part No	) <b>:</b>	PAR #:	Fault Categ	ory:	NCR:	Yes N	lo <b>DQ</b>	A:	_ Date: _	
	Re	solution:	Disposition	ı:	QA: I	V/C Clo	sed:		Date:	
NCR:			WORK ORDE	R NON-CONFORM	MANCE	(NCR)				
DATE	STEP	Description of NC	·	<del> </del>	ection B	Sign &		cation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	1	Date Date	Secti	on C	Chief Eng	QC Inspector
ı			;		-					
1										
1										
•										
•										
								,		

NOTE: Date & initial all entries

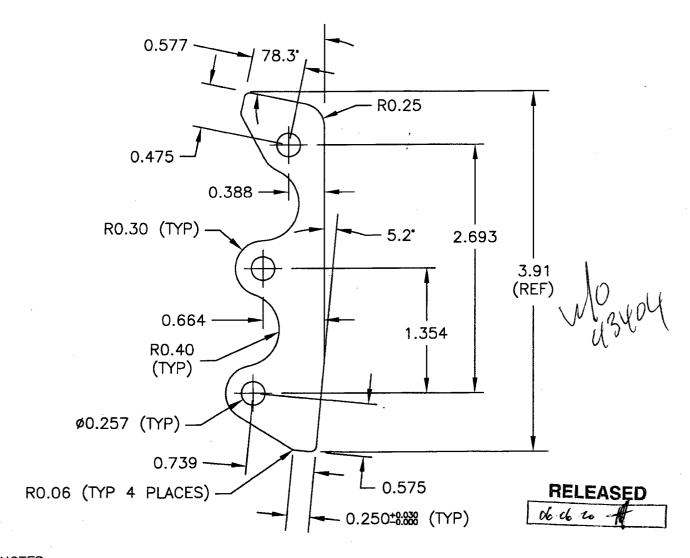
¹ Thursday, 13/11/2008 8:08:28 AM User: Linda Lacelle **Process Sheet** Drawing Name: SADDLE SPACER Customer: CU-DAR001 Dart Helicopters Services Part Number: D2935 Job Number: 43404 Job Number: Seq. #: Description: Machine Or Operation: INSPECT POWDER COAT/CHEMICAL CONVERSION 6.0 QC3 COUNTE Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING RESOURCE #1 7.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 50 QC21 FINAL INSPECTION/W/O RELEASE 8.0 Comment: FINAL INSPECTION/W/O RELEASE Job Completion

Dan Ae	rospace	Lia								
W/O:			WO	RK ORDER CHANG	SES					
DATE	STEP	PRO	OCEDURE CHAN	IGE	В	y	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					-					
:									· · · · · · · · · · · · · · · · · · ·	
<u> </u>										
Part No	:	PAR #:	Fault Categ	ory:	_ NCR: `	res N	o <b>DQ</b> /	<b>A</b> :	_ Date: _	
	Re	solution:	Disposition	:	QA: N/	C Clos	sed:		Date: _	
NCR:		· · · · · · · · · · · · · · · · · · ·	WORK ORDE	R NON-CONFORM	ANCE (I	NCR)				
<del></del> .	OTED	Description of NC	<u> </u>		tion B		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date	Secti		Chief Eng	QC Inspector
										<u> </u>
I										
<u> </u>										
1										
•										

NOTE: Date & initial all entries



DESIG	·	DRAWN BY	DART AEROSPACE US	SA, INC.
CHECK		APPROVED	DRAWING NO.	REV. B
	PH		D2935	SHEET 1 OF 1
DATE		· · · · · · · · · · · · · · · · · · ·	TITLE	SCALE
06.0	5.29		SADDLE SPACER	1:1
Α		99.11.02	NEW ISSUE	
В		06.05.29	ADD 6061-T6 MATERIAL	



### **NOTES:**

1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)

OR

5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC M5052H32S.080)

- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

Copyright © 1999 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Dart	<b>Aeros</b>	pace	Ltd
------	--------------	------	-----

•							
		WC	RK ORDER CHANG	ES			
STEP	PR	OCEDURE CHAI	NGE	Ву	Date	Qty Approval Chief Eng / Prod Mgr	Approval QC Inspector
:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No <b>DQA</b> :	Date: _	
Re	esolution:	Disposition	n:	_ QA: N/C CI	osed:	Date: _	
		WORK ORDI	ER NON-CONFORMA	ANCE (NCF	R)		
OTED	Description of NC				Verifica	tion Approval	Approval
SIEP	Section A	Initial Chief Eng	Action Description  Chief Eng	Sign & Date			QC Inspector
	):	PAR #:	STEP PROCEDURE CHAIN  PAR #: Fault Cate  Resolution: Disposition  WORK ORDI  STEP Description of NC  Section A Initial	STEP PROCEDURE CHANGE  PAR #: Fault Category:  Resolution: Disposition:  WORK ORDER NON-CONFORM  STEP Description of NC Section A Corrective Action Section A Corrective Action Description	PAR #: Fault Category: NCR: Yes  Resolution: Disposition: QA: N/C CI  WORK ORDER NON-CONFORMANCE (NCF  WORK ORDER NON-CONFORMANCE (NCF  STEP Description of NC Section A Initial Action Description Sign 8	STEP PROCEDURE CHANGE By Date  Disposition: QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR)  STEP Description of NC Section A Section B	STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr  D:PAR #: Fault Category: NCR: Yes No DQA: Date:  Resolution: Disposition: QA: N/C Closed: Date:  WORK ORDER NON-CONFORMANCE (NCR)  STEP Description of NC Section A Description Sign & Section C Section C Section C Chief Eng / Prod Mgr

NOTE: Date & initial all entries

DART AEROSE	PACE LTD	 Work Order:	43404	
DAIL! ACITOO!	<u> </u>	46		
Description:	SADOLE	SPACER *	Part Number:	D963C
				5
Inspection Dwg:	D2935, Rev:	K		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Rejest	Method of inspection	Comments
(75 <sub>6</sub> , Ø	1.006 - 001	979	¥			
7 ,739	4/- ,010	740	6	·		
, 664	4/610	600,	<b>K</b>			
388	4010	,388	×			1.0
1,354	4010	1,354	8			
2.693	4610	2.697	×			
3.91	1/030	3,92	×			
,577	4010	. 580	12			
475	4010	,476	b			
, 675	4/_ ,010	,518	<b>X</b>			
		٠.				
					·.	• •
			1 4 min 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2	S		
·			·			
			•			<u>.</u>
·						
		·				
	s.	·				
		ż		,		
		. 4				

							<b> </b>
Measured by:	rR.	Audited by:	\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \	$\bigcap \bigcap$	Prototype Approval:	\lambda_{\begin{subarray}{c} \lambda_{\begin}	
Date:	8-11-12	Date:	astulia	7	Date:	. [	A
		<u> </u>	<del></del>	سا لس	*		

Rev	Date	Change	Revised by	Approved
Α		New Issue	KJ/JLM	السروسا
		•		